

Date: Friday, 15/08/2008 1:19:41 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
Job Number : 41258
Estimate Number : 10804
P.O. Number :
This Issue : 15/08/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : CROSSTUBES
Previous Run : 41182
Written By :
Checked & Approved By :
Comment :

Drawing Name : D407-667-205

Part Number : D407667205
Drawing Number : ECN1225 - REWORK
Project Number :
Drawing Revision :
Material :
Due Date : 26/08/2008 Qty: 1 Um: Each

Additional Product

Job Number:



DART Dart Aerospace Ltd. 2270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7		TO APPROVAL # 09-89 TEL: 1-613-632-5200	
DESC.	D407-667-205	CHG	CHG004
LOT	B38167	STC	SH01-5
MODEL	Bell 407	STC	SR01304NY
MADE IN CANADA		02729-1	

Seq. #: Machine Or Operation:

Description

1.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

PULL FROM STOCK:

1 X D407-667-205 B38167 CHG004

15/08/25 (1)

2.0

D407667205

Crosstube Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Crosstube Aft

ml 08 08 27 (1)

3.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1
REWORK TUBE PER ECN1225
MOVE BOTH CHAFING SHIELDS 0.375"
TOWARD BL 0.0.

ml 08 08 27 (1)

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/09/28 (4)

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT FOR ORIGINAL KIT
TO BE INCLUDED

5 08/09/29 (4)

Date: Friday, 15/08/2008 1:19:41 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 41258

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



08/08/29
Comment: PACKAGING RESOURCE #1
REPACKAGE USING NEW B/N
@ CHG 006
NEW LABELS REQ'D

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-29

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 08.07.17	Job No.:	ADR Yes/No: <input checked="" type="checkbox"/> Y	ADR Date: 08.07.17	ECN #: 1225
Product No.: D407-667-245		Created By: <i>[Signature]</i>	Approved By: <i>[Signature]</i>	
Product Name: CROSSTUBE ASS'Y (407 HIGH AFT)		Checked By: <i>[Signature]</i>	General Manager Approval:	

Distribution	Reqd	Resp	Received
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	
Director Quality Assurance	N		
Customer Order Processing	N		

Distribution	Reqd	Resp	Received
Customer Technical Support	Y	DS	
Marketing	N		

Reason for Change:

REVISED SUPPORT LOCATION ON CROSSTUBE: MOVED EACH SUPPORT 3/8" TOWARD BL0.0 (CROSSTUBE'S CENTERLINE) PER CAR#08-21

Documents Affected:

RELEASE D407-667-245 REV. E

#	Engineering Actions	Reqd	Resp	Notes	Complete
1	Required Documents/Drawings Under Review	Y	CP		<i>[Signature]</i> 08.03.17
2	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		
3	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		
4	Update Grey Project Binder	Y	KJ	ADR	
5	Move Electronic Files	Y	KJ		
6	Update Master Document List (MDL)	Y	MB		<i>[Signature]</i> 08.06.07
7	Update Document Record (DR)	Y	KJ		
8	Create/Update Change Record Form	Y	KJ	-205 NOW @ CHG 006 AND -205A @ CHG 004	
9	Create/Update PPP's	Y	KJ	AS REQUIRED	
10	Update Controlled PDF Files	Y	KJ		
11	Notify TC/FAA of Change	N			
12	Update QSI 021 and/or STC Approval List	N			
13	Update Product Development Summary	N			
14	Update Accpac Database	N			
15	Update Access (ARC) Database	N			
16	Update/Verify ARC	N			
17	Update Paperwork Kits in Production	Y	KJ	AS REQUIRED	
18	Update Qpulse/Laminated Dwgs	N			
19	Update Product Compatibility Matrix	N			
20	Create Eurocopter Form (FEE)	N			
21					

#	Production Actions	Reqd	Resp	Notes	Complete
22	Create/Update Coss IPP/BOM	Y	EC/DD	AS REQUIRED + SEE BELOW	
23	Update FAI Sheets	Y	EC/DD	AS REQUIRED + SEE BELOW	
24	Create/Update CNC Programs	N			
25	Create/Update Tooling	Y	EC/DD	AS REQUIRED + SEE BELOW	
26	Red Tag Stock (Specify)	Y	JM	PER CAR#08-21	
27	Rework/Scrap Current Production and/or Stock	Y	LL	REWORK AS REQUIRED.	
28	Update Paperwork Kits in Stock	N			
29	Create/Update MPP	Y	EC/DD	AS REQUIRED	
30					

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
31	Notify Previous Customers	N			
32	Notify Eurocopter France	N			
33					

Description / Action:

TAKE NOTE THAT THE DWG HAS CHANGED CONSIDERABLY TO REFLECT THE LATEST DART'S DWG STDS.
 REVIEW ANY OF THE PRODUCTION'S DOCUMENTS REFERRING TO SPECIFIC VIEWS OR CALLOUTS.
 VERIFY NEW LOCATION OF SUPPORTS PRIOR REMOVING THE ABRASION STRIPS. RELOCATE ABRASION STRIPS ONLY IF NECESSARY.

AMENDMENT DESIGN REVIEW (ADR)Part/Installation No.: D407-667-245 Rev: E Design Review No.: _____ Date: 08.07.31Project Number: 00056 Project Description/Title: CROSSTUBEEng. Project Manager: M. BELLAVANCE ASSY (407 HIGH AFT)

Persons Present	Title	Initial
MIKE PETSCHÉ	Design Manager	<i>MP</i>
M. BELLAVANCE	Engineering Project Manager	<i>MB</i>
D. SHEPHERD	Chief Engineer (DE #02)	<i>DS</i>
	Manufacturing Manager	
	Quality Manager	
J. MURDOCH	Q.C. Inspector	<i>JM</i>

Comments

GENE LEBLANC, AIR LOGISTIC'S INSPECTOR, REPORTED THAT THE INNER MOST CLAMPS FASTENING THE CHAFFING SHIELDS INTERFERE WITH THE AIRCRAFT'S ROCKER BEAM MOUNTS (REF. PAR#08-21).

IT WAS DETERMINED THAT THIS INTERFERENCE CAN BE ELIMINATED BY MOVING BOTH CHAFFING SHIELDS 0.375" TOWARD BL 0.0.

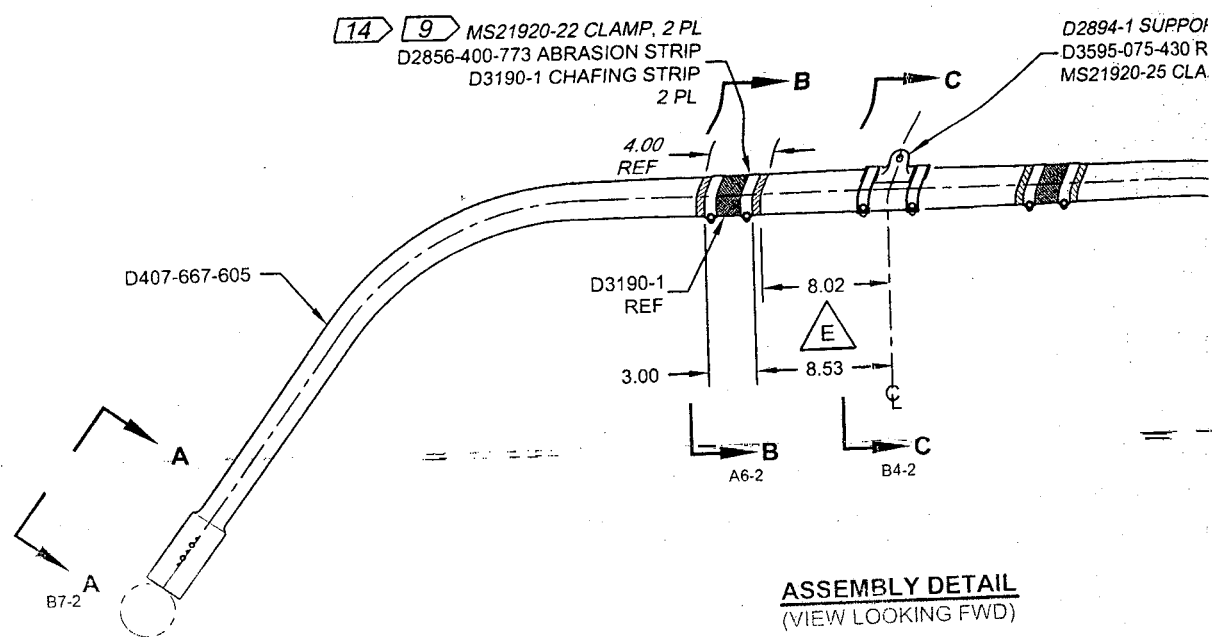
THIS IS A MINOR DIMENSIONAL CHANGE AND APPROVAL BY DE#02 IS ACCEPTABLE.

41182
41195

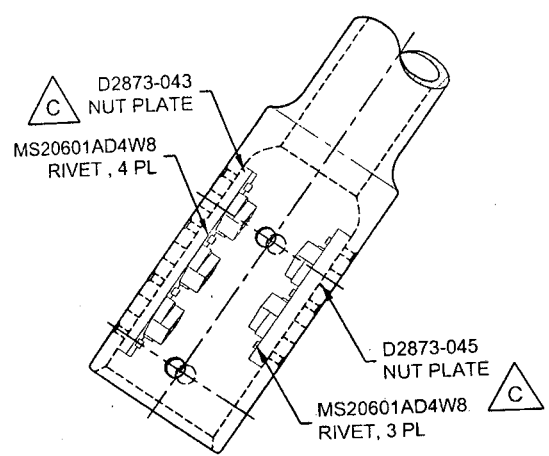
Key Tasks (Check or N/A)	Check	Responsible	Completion Date
Review Outstanding TSR/NCR/CAR/PAR	Y	MP	
Fill out Criteria/Constraints Form – Inputs	N/A		
Fill out Project Evaluation Form	N/A		
D-Part creation/revision	Y	MB	
Get Manufacturing Input	N/A		
First Article Inspection	N/A		
Fit and Function Test	N/A		
Structural Test	N/A		
Reports (Compliance, Loads, Stress, Conformity, DSI)	N/A		
Check Drawings against all QSIs	Y	MB	
Review Criteria/Constraints Form	N/A		
Revision to existing approval	N/A		
Close Amendment Project	Y	MB	

Conclusion:

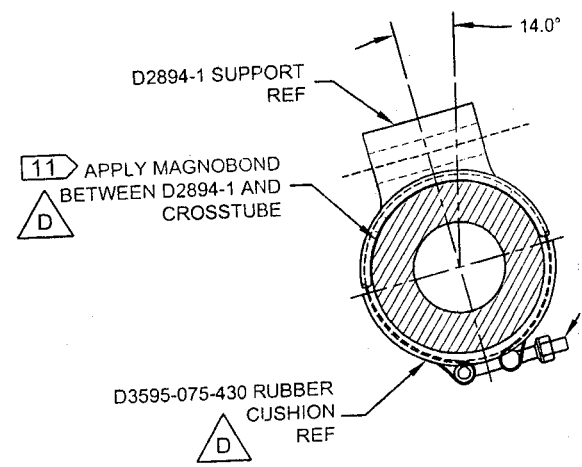
PROCEED WITH THE REVISION OF DRAWING D407-667-245 FROM REV. D TO REV. E AND RELEASE THROUGH ECN#1225.



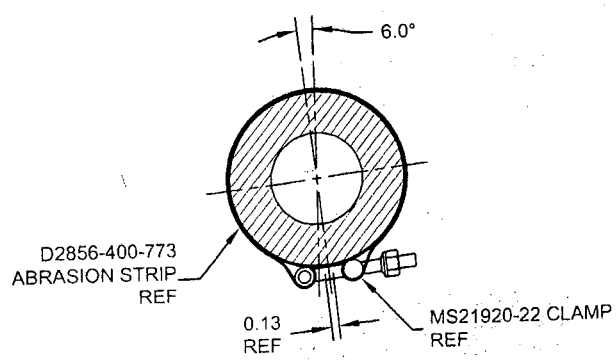
ASSEMBLY DETAIL
(VIEW LOOKING FWD)



VIEW A-A CUFF DETAIL
SCALE 4X

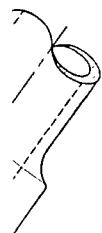
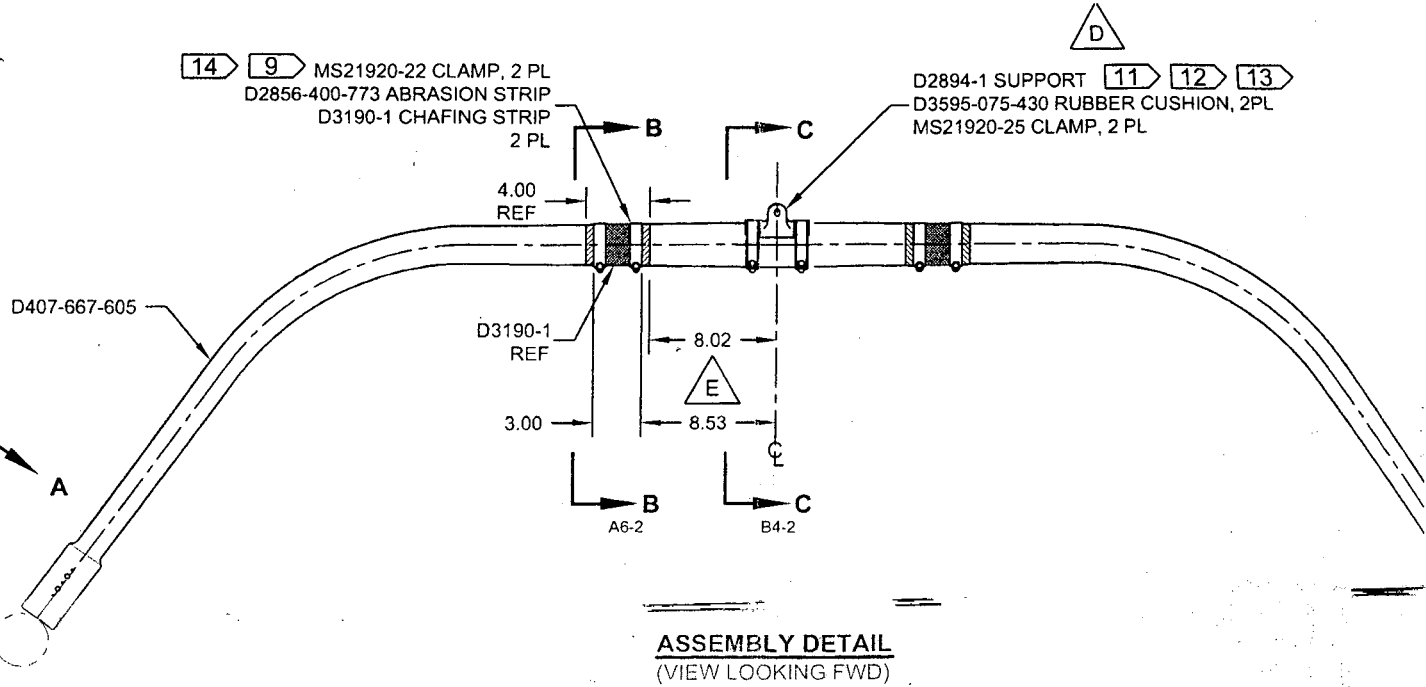


SECTION C-C
SCALE 4X



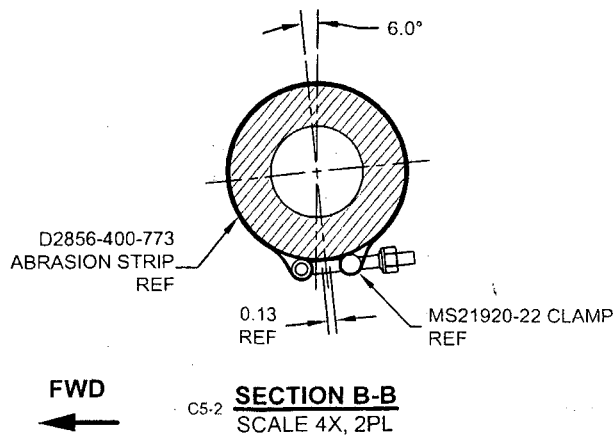
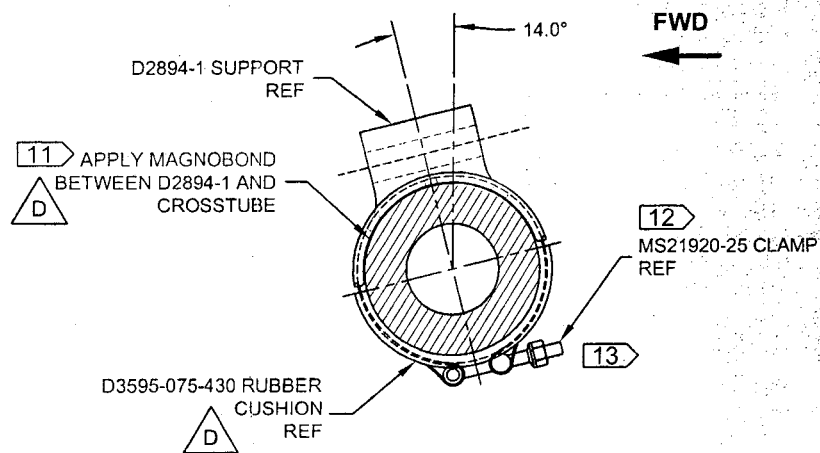
FWD

SECTION B-B
SCALE 4X, 2PL



D2873-045
NUT PLATE
301AD4W8
3 PL

DIFF DETAIL
SCALE 4X



DESIGN
DRAWN
CHECKED
MFG. APPR
APPROVED
DE APPR
DATE

6

5

4

3

Under Review Notification

Raised By: Chris Provencal

Date: 08.07.17

Product #: D206-667

Product Name: Crosstubes

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D407-667-245	Crosstube Assy (407 Hi AFT)	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	per -205 below
D407-667-205	Crosstube Instl (407 Hi AFT)	8	0	0	Y	Y	N	Y	Y	Y	Y	1225	
D407-667-205A	Crosstube Instl (407 w/ coating)	0	0	0	Y	Y	N	Y	Y	Y	Y	1225	

Description of issue:

- The inner clamps on the chafing shield interfere with the mounts on the aircraft.
- Dwg D407-667-245 Rev. D is now under review
- This affects both the D407-667-205 & D407-667-205A xtubes
- Place bluefile under review for D407-667-205 & D307-667-205A xtubes only, other xtubes are OK to ship
- Stock was already quarantined per CAR 08-21, see CAR for further action items (ie. rework).
- Dwg will be revised to Rev. E and D407-667-205 will have a new change number per ECN 1225
- D407-667-205TRN will not be affected by this change

Distribution:

General Manager
 Production Manager
 Director Quality Assurance
 Design Manager
 Chief Engineer

Production Engineering Coordinators
 Quality Assurance Coordinator
 Quality Control Coordinator
 Order Processing
 Customer Technical Support

Engineering Project Managers
 Engineering Clerk
 Marketing

Date: Friday, 15/08/2008 1:19:41 PM
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Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D407-667-205
Job Number	: 41258		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D407667205
This Issue	: 15/08/2008	S.O. No. :	Drawing Number : ECN1225 - REWORK
Prsht Rev.	: NC	Project Number	:
First Issue	: / /	Type	: CROSSTUBES
Previous Run	: 41182	Drawing Revision	:
		Material	:
Written By	:	Due Date	: 26/08/2008
Checked & Approved By	:	Qty:	1 Um: Each
Comment	:		

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	CROSSTUBES	CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

PULL FROM STOCK:

1 X D407-667-205 B38167

REFERENCE ONLY

2.0	D407667205	Crosstube Aft
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REFERENCE ONLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Crosstube Aft

3.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: CROSSTUBES RESOURCE 1
REWORK TUBE PER ECN1225
MOVE BOTH CHAFING SHIELDS 0.375"
TOWARD BL 0.0.

4.0	QC5	INSPECT WORK TO CURRENT STEP
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REFERENCE ONLY



Comment: INSPECT WORK TO CURRENT STEP

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT FOR ORIGINAL KIT
TO BE INCLUDED

Date: Friday, 15/08/2008 1:19:41 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 41258

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE USING NEW B/N

@ CHG 006

NEW LABELS REQ'D

JW 08.8.20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Hot Crossbuds

Chasing shield - longer -

Mod 777

Nike / Chris



→ WRD - foam end of this wk - Chestnut? due?

→ updating guy - call to tell him another set on its way

weapshots to be welded - cleanup on

D3780-041 est. 20M rest

→ Tbu Ring D3407- D3456-1? D3447-1 - D3493-1

NASIS > D3672's
folding steps what kind part it

eyebolt to hang
and make strut longer

needs LH floor
D3487-1
Joan

WRD - line to slip
to 2296
12th. 20/203
roller brackets - line 20

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Mark
SIC 234 451
SIC 331 1055
Oct 22 2008

Parker